



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3640-1
Job Sheet 191504



Part No: D3640-1

Job Qty: 12 pcs

Part Name: Belt Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	3/22/19	3/22/19	0.00	0.27	Bandsaw - 1		mm 19/03/20
110	HAAS 4 Axis - B4B	12 pcs	3/22/19	3/22/19	0.33	3.73	HAAS - 1 - B4B		mm 19/03/23
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs	3/22/19	3/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33	QC-23	mm 19/03/23
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
140	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	3/22/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S164491



Part: D3640-1

Job No: 191504

Serial No/Batch: S164491

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/20/19

Plex 3/4/19 8:22 AM Dart.lajeunesse.marie

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	DAS
				Packaging 3 - 9 - B4B	28
				Packaging 3 - 10 - B4B	9-89
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
					21
					9-89
150	QC 21 - SA	12 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - (Bandsaw) Cut blank 4.700 " long
 Descriptions: **110** - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA670 & Dwg D3640 Rev: _____ 2-Debur and Blend rad
 intersection with deburring tool.
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____)
150 - (QC21- Final Inspection - Work Order Release)

MAR 26 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB0.750X1.250	Delrin Bar	4.8000 ft (.4 ea)	100-Bandsaw - 1	5068422 = 4.74

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRLNB0.750X1.250	5	57	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Belt Guide	4.500Inches $\pm$ 0.030	4.530 4.470		4.497
2	Belt Guide	0.800Inches $\pm$ 0.030	0.830 0.770		.795
3	Belt Guide	0.130Inches $\pm$ 0.030	0.160 0.100		.125
4	Belt Guide	0.310Inches $\pm$ 0.030	0.340 0.280		.310
5	Belt Guide	0.200Inches $\pm$ 0.010	0.210 0.190		.201
6	Belt Guide	0.400Inches $\pm$ 0.030	0.430 0.370		.395
7	Belt Guide	0.030Inches $\pm$ 0.030	0.060 0.000		.030
8	Belt Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	45
9	Belt Guide	0.230Inches $\pm$ 0.030	0.260 0.200		.237
10	Belt Guide	0.400Inches $\pm$ 0.030	0.430 0.370		.403
11	Belt Guide	0.625Inches $\pm$ 0.010	0.635 0.615		.627
12	Belt Guide	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	.125

Plex 3/4/19 8:22 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					